

Date: Wednesday, 10/09/2008 1:52:42 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BRACKET |
| Job Number | : 41929 | | |
| Estimate Number | : 10737 | | |
| P.O. Number | : | Part Number | : D31261 |
| This Issue | : 10/09/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D3126 REV A1 |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 36728 | Drawing Revision | : A1 |
| | Type : SMALL / MED FAB | Material | : |
| Written By | : | Due Date | : 17/09/2008 |
| Checked & Approved By | : <u>JUL 08 9.10</u> | Qty: | 10 Um: Each |
| Comment | : Est A03.01.15 New issue KJ/RF Est Rev:B Now On Waterjet 07-04-19 JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S22GA | 304/316 .032 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.0623 sf(s)/Unit Total: 0.6227 sf(s)

304/316 .032 Sheet

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3126

Dwg Rev: A1Prog Rev: A1

B 8-9-16

2-Deburr if necessary B 8-9-16

(12)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

B 8-9-16

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

8 08/09/17 (12)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|

**Comment:** NC BRAKE

Deburr if necessary

Form on CNC brake as per D3126 using Jig D3126T1 Identify as D3126-1

Scribe Dart P/N as shown on Dwg D3126

SB 09/04/01

ep 09/04/01

(12)

(12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 1:52:42 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 41929

Part Number: D31261

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8020401 v12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 66

9/4/02

(120)

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/02

Job Completion



MF
09-0402

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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
NOTE: Date & initial all entries



| | | | |
|-----------------------|---------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 41929 |
| Description: Bracket | | Part Number: | D3126-1 |
| Inspection Dwg: D3126 | Rev: A1 | Page 1 of 1 | |

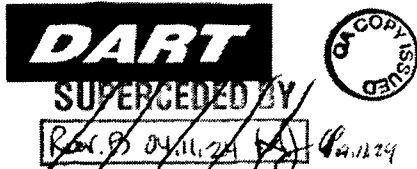
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.200 | +/-0.010 | .208 | * | | | |
| 0.800 | +/-0.010 | .808 | * | | | |
| 0.524 | +/-0.010 | .525 | * | | | |
| 1.500 | +/-0.010 | 1.506 | * | | | |
| 3.000 | +/-0.010 | 3.007 | * | | | |
| 1.925 | +/-0.010 | 1.928 | * | | | |
| 0.976 | +/-0.010 | .980 | * | | | |
| 0.260 | +/-0.010 | .258 | * | | | |
| 2.832 | +/-0.010 | 2.829 | * | | | |
| 1.830 | +/-0.010 | 1.827 | * | | | |
| 0.585 | +/-0.010 | .586 | * | | | |
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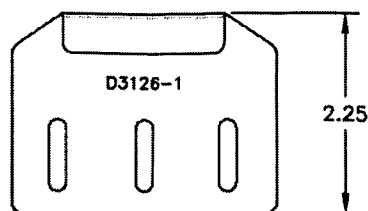
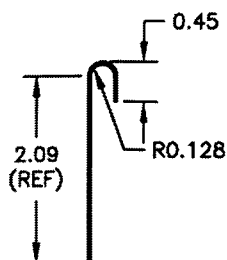
| | | | |
|--|---|---------------------|-----|
| Measured by:  | Audited by:  | Prototype Approval: | N/A |
| Date: 8-9-16 | Date: 08/02/17 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|---|---|
| A | 08.02.28 | New Issue | KJ/DD  |  |

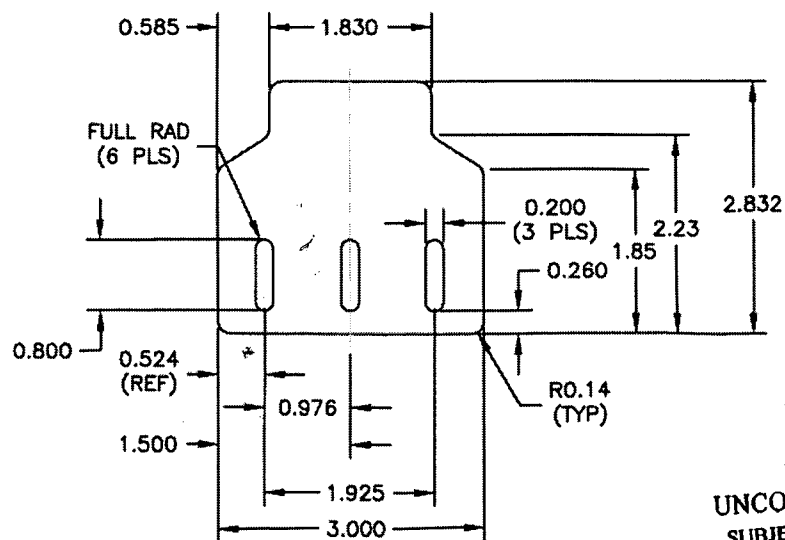


| | | | |
|------------------|------------------|---|------------------------|
| DESIGN # | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3126 | REV. A SHEET 1 OF 3 |
| DATE 02.04.17 | TITLE BRACKET | | SCALE 1:2 |
| A | 02.04.17 | NEW ISSUE | |
| AI | 02.07.23 | ADD "ANNEALED" SPEC | |

RELEASED
02.05.27



D3126-1 BRACKET
REPLACES PREMIER P/N B30-23000-265



D3126-1 BRACKET FLAT PATTERN

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41929

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-1 AS SHOWN

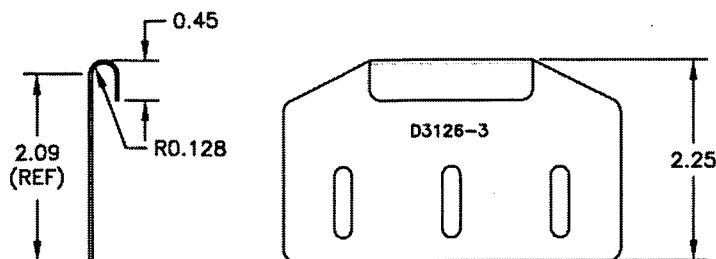
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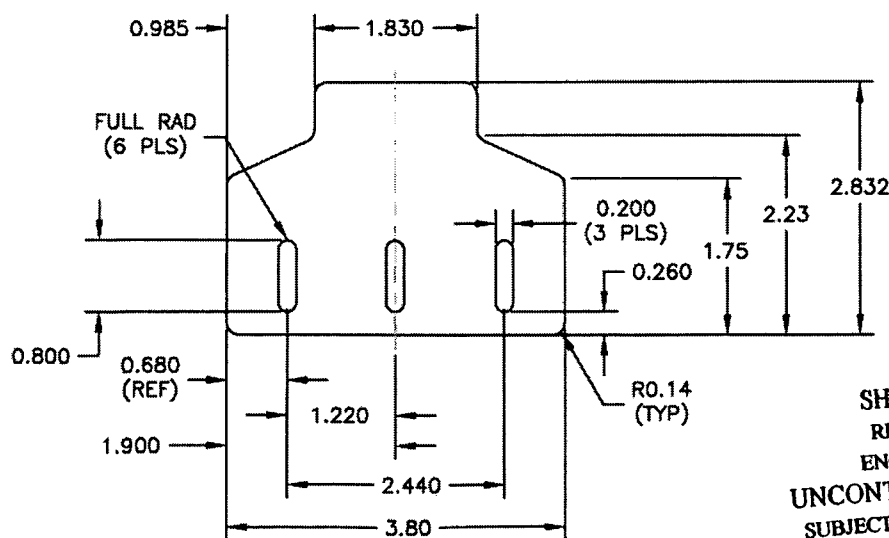


| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3126 | REV. A SHEET 2 OF 3 |
| DATE 02.04.17 | | TITLE BRACKET | SCALE 1:2 |

RELEASED
02.05.27



D3126-3 BRACKET
REPLACES PREMIER P/N B30-23000-267



D3126-3 BRACKET FLAT PATTERN

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NO. 41929

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-3 AS SHOWN

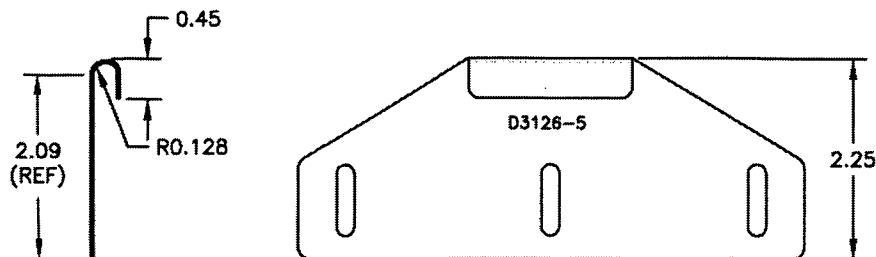
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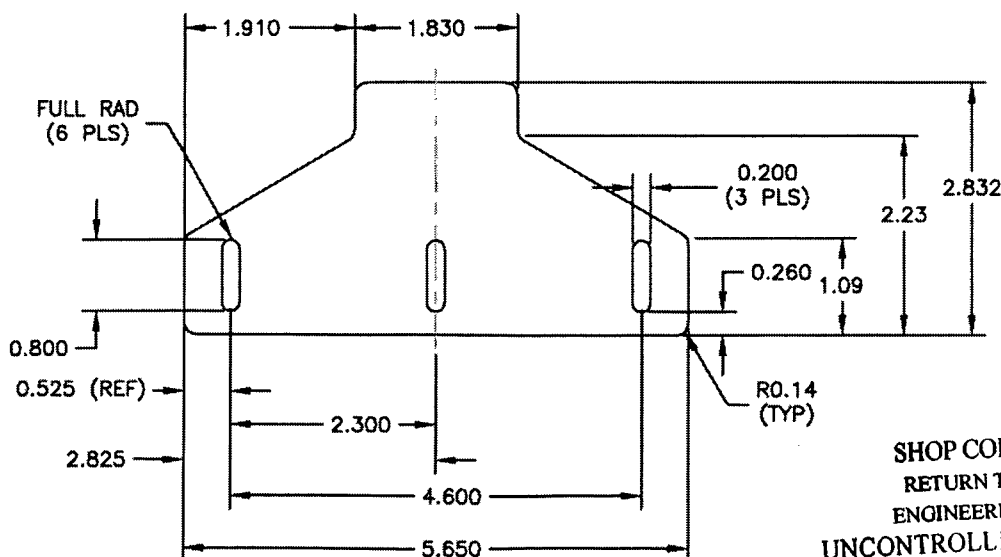


| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3126 | REV. A SHEET 3 OF 3 |
| DATE 02.04.17 | | TITLE BRACKET | SCALE 1:2 |

RELEASED
02.05.27 #



D3126-5 BRACKET
REPLACES PREMIER P/N B30-23000-269



D3126-5 BRACKET FLAT PATTERN

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NO. 019029

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) SCRIBE DART P/N D3126-5 AS SHOWN

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